

ACAP

June 9 2007

Dart Aerospace Ltd.

Date: Wednesday, 5/23/2007 4:10:56 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GPS RECEIVER HOUSING  
 Job Number : 32536  
 Estimate Number : 12492  
 P.O. Number : N/A Part Number : D35143  
 This Issue : 5/23/2007 S.O. No. N/A Drawing Number : UNDER REVIEW 07.05.29  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : N/A  
 Previous Run : 28418 Material : N/A  
 Due Date : 5/30/2007 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : 07.05.29  
 Comment : Est Rev.A New Issue 06-07-26 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.4812 sf(s)/Unit Total : 1.9249 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M02723 ml 070529

(4)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: Prel

Prog Rev: Prel

ml 070529

(4)

\*\*\*Ensure Grain Direction is correct\*\*\*\*\*

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 070529



(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



0705-29 (4)



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Countersink as per Dwg D3514

FF 07-05-30

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 4:10:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 32536

Part Number: D35143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/30 (4)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3514

SB 07/05/30 (4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-05-30 (4)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SB 07-05-30 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

U ml 07/05/30 x4

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GA X3 ml 07/05/30

ENG APPROVAL  
CB 07.05.31

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ST 144

7/5/30 SP

SB 07/05/31 (4)

Job Completion



U 7-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

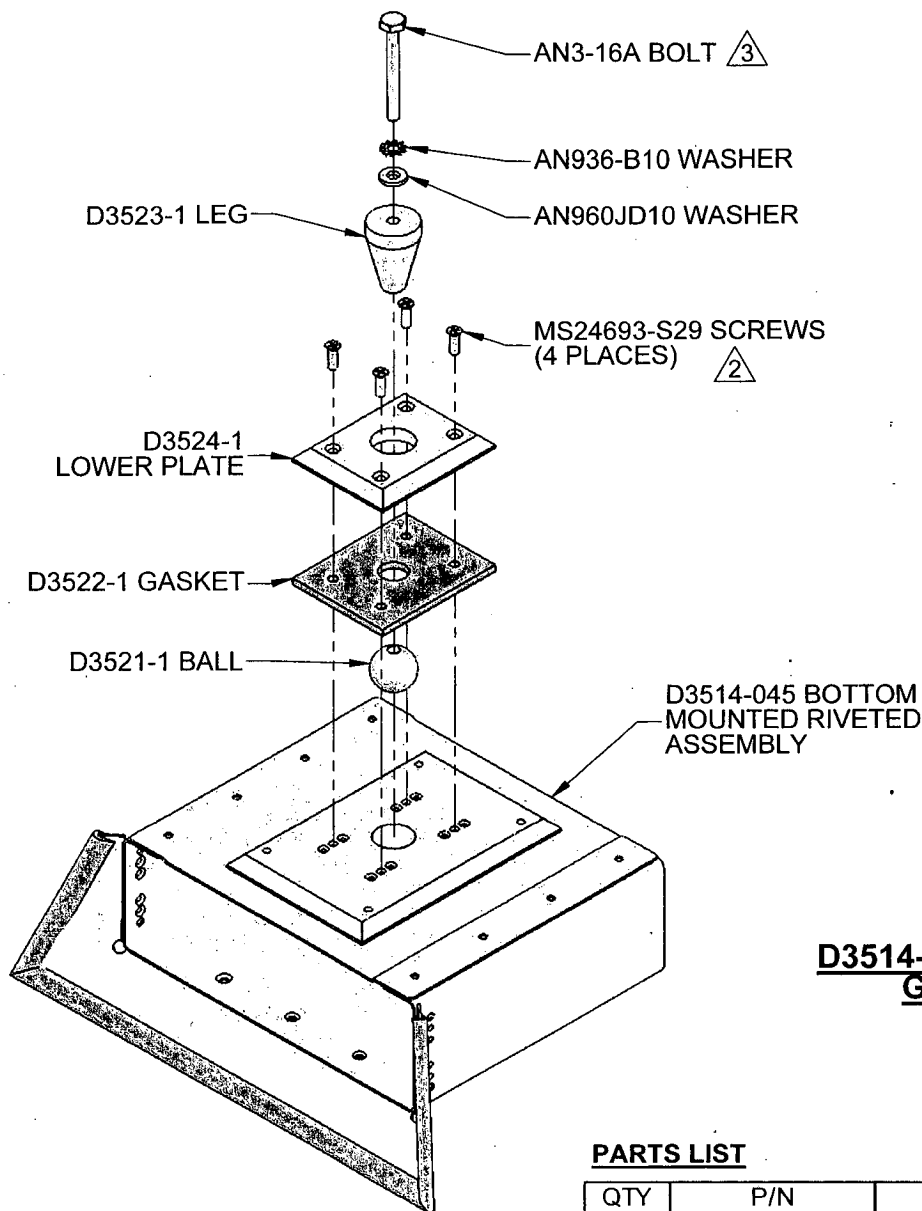
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>PH</b>	APPROVED	DRAWING NO. <b>D3514</b>	REV. A SHEET 1 OF 9
DATE <b>07.01.10</b>	TITLE <b>GPS RECEIVER HOUSING</b>		SCALE 1:3



**PRELIMINARY ISSUE**

**UNDER REVIEW**

**07.05.24CB**

**D3514-041 BOTTOM MOUNTED GIMBAL ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO **32536**

**PARTS LIST**

QTY	P/N	DESCRIPTION
<b>X</b>	<b>D3514-041</b>	<b>BOTTOM MOUNTED GIMBAL ASSEMBLY</b>
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3521-1	BALL
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
1	AN3-16A	BOLT
1	AN936-B10	WASHER
1	AN960JD10	WASHER
4	MS24693-S29	SCREWS

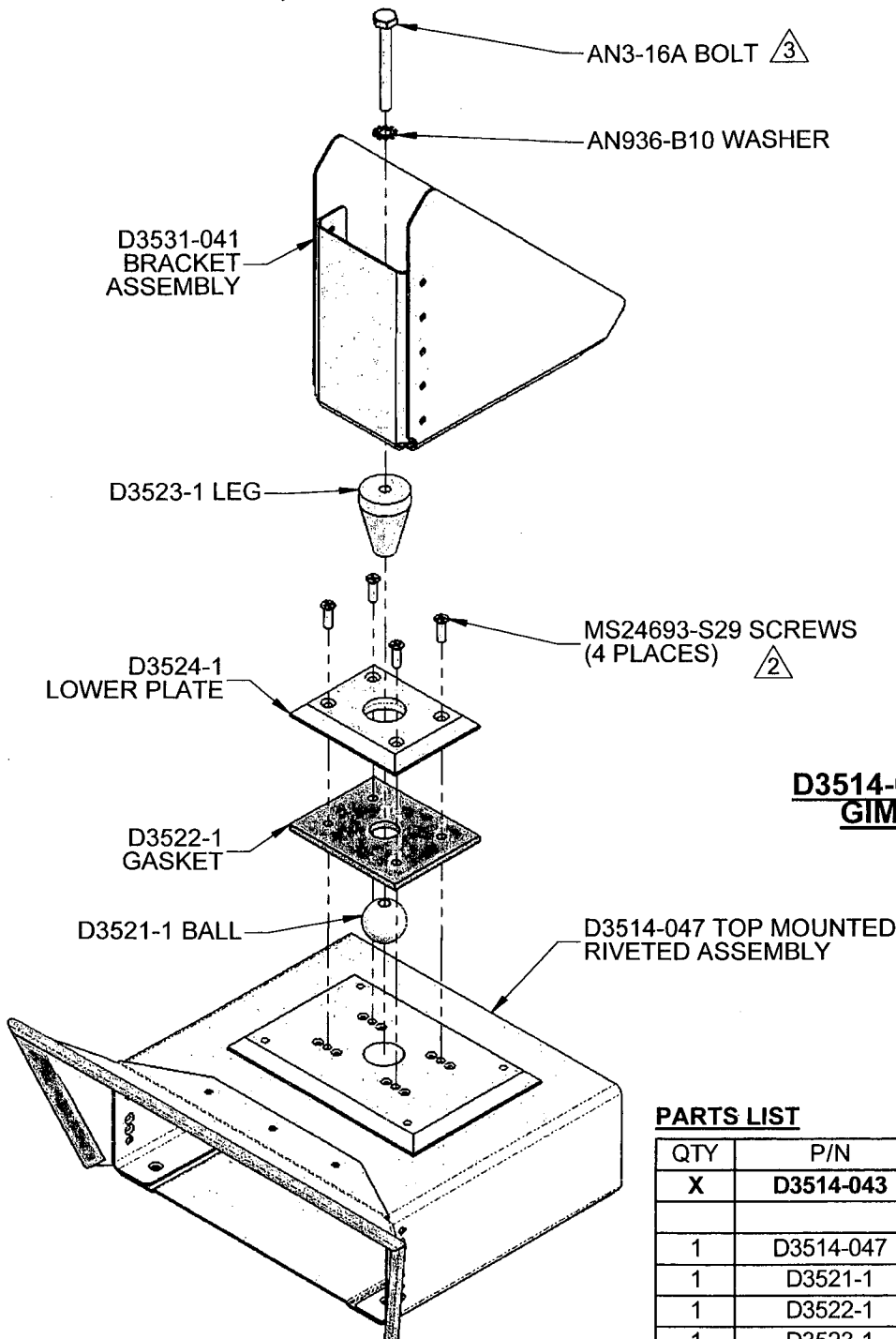
**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER

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CHECKED <b>PH</b>	APPROVED	DRAWING NO. <b>D3514</b>	REV. A SHEET 2 OF 9
DATE <b>07.01.10</b>	TITLE <b>GPS RECEIVER HOUSING</b>		SCALE 1:3



**PRELIMINARY ISSUE**

**UNDER REVIEW**

**07.05.24 CB**

**D3514-043 TOP MOUNTED GIMBAL ASSEMBLY**

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WORK ORDER  
NO. **32536**

**PARTS LIST**

QTY	P/N	DESCRIPTION
<b>X</b>	<b>D3514-043</b>	<b>TOP MOUNTED GIMBAL ASSEMBLY</b>
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3521-1	BALL
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
1	AN3-16A	BOLT
1	AN936-B10	WASHER
4	MS24693-S29	SCREWS

**NOTE:**

- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER

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PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3514	REV. A SHEET 3 OF 9
DATE 07.01.10	TITLE GPS RECEIVER HOUSING		SCALE 1:3
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE	

UNDER REVIEW

07.05.24CB

D3514-1 BOX TOP  
(BOTTOM MOUNTED)

MS20426AD4-4 RIVETS  
(3 PLACES)

D3514-9 HOOD

D3526-1  
RUBBER  
SEAL

MS21072L06 ANCHOR NUT (1)  
MS20426AD3-4 RIVETS (2)  
(4 PLACES)

MS20426AD4-4 RIVETS  
(8 PLACES)

MS20426AD4-8 RIVETS  
(4 PLACES)

D3524-041 UPPER  
PLATE ASSEMBLY

D3514-5 BOX BOTTOM  
(BOTTOM MOUNTED)

WORK ORDER  
NO. 32536

### D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

#### NOTES:

- 1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

#### PARTS LIST

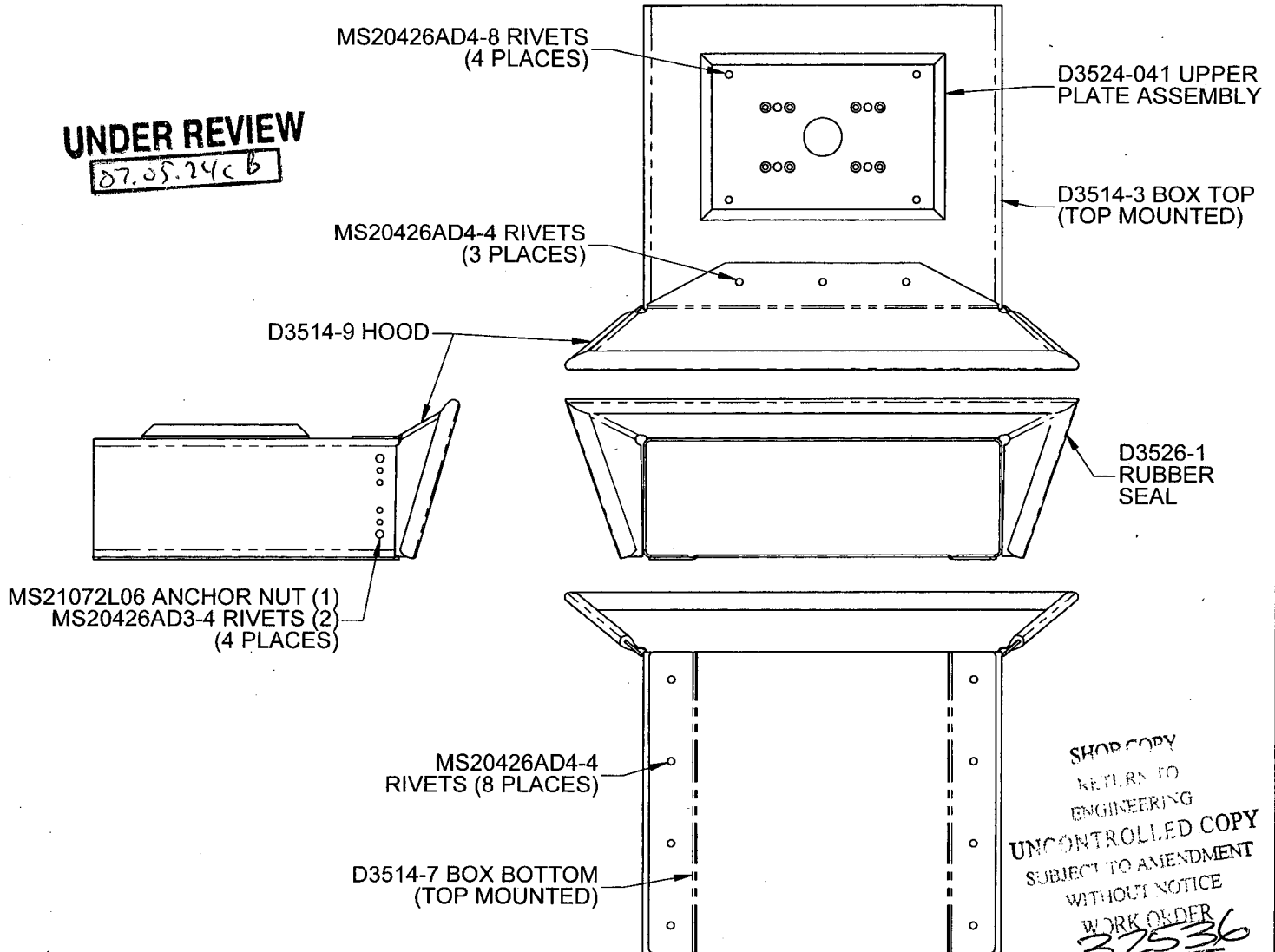
QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-4	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-8	RIVET
4	MS21072L06	ANCHOR NUT

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**PRELIMINARY ISSUE**

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CHECKED <b>PH</b>	APPROVED	DRAWING NO. <b>D3514</b>	REV. A SHEET 4 OF 9
DATE <b>07.01.10</b>		TITLE <b>GPS RECEIVER HOUSING</b>	SCALE 1:3



**D3514-047 TOP MOUNTED  
HOUSING ASSEMBLY**

**NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK  
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

**PARTS LIST**

QTY	P/N	DESCRIPTION
<b>X</b>	<b>D3514-047</b>	<b>TOP MOUNTED HOUSING ASSEMBLY</b>
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-4	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-8	RIVET
4	MS21072L06	ANCHOR NUT

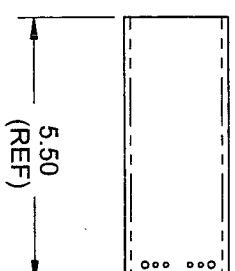
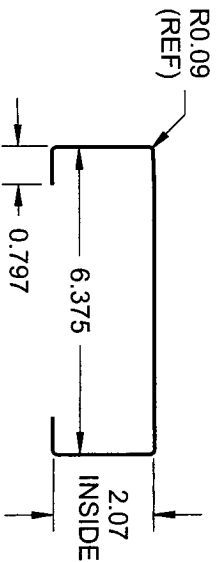
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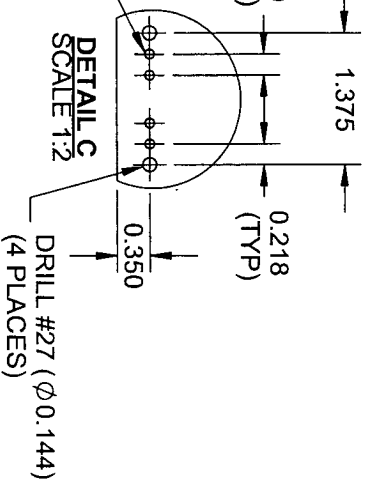
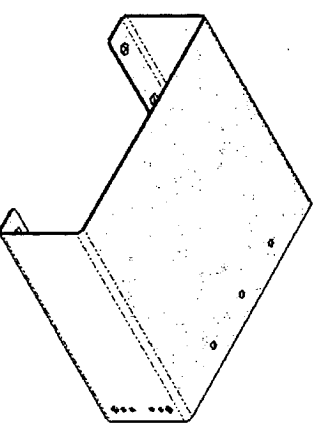
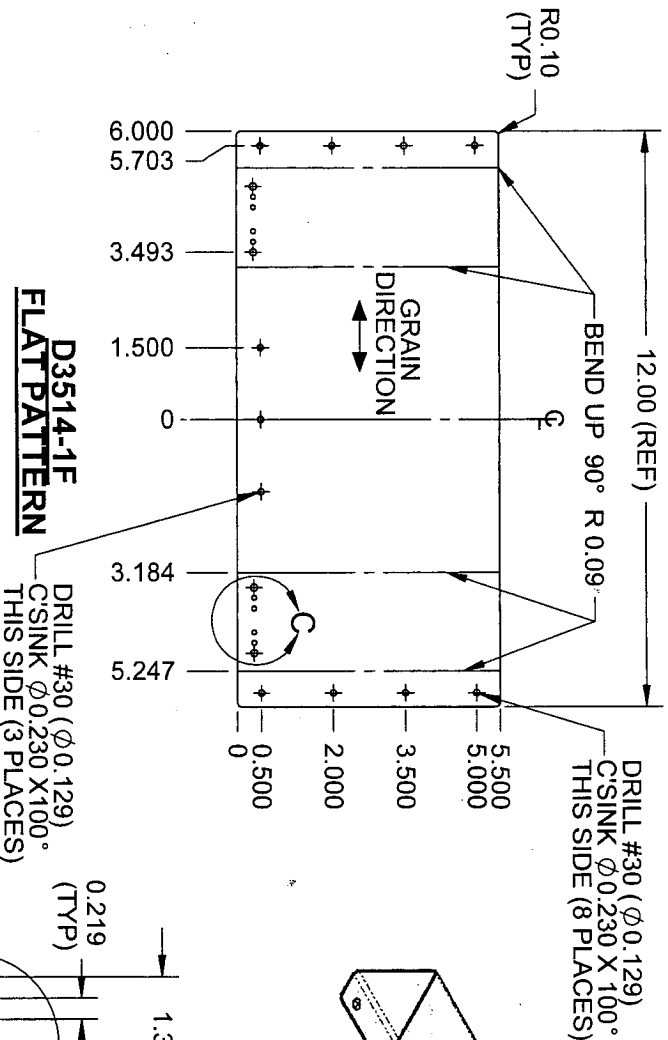


# PRELIMINARY ISSUE

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. <b>D3514</b>
DATE <b>07.01.10</b>	TITLE <b>GPS RECEIVER HOUSING</b>	REV. A SHEET 5 OF 9
	SCALE <b>1:4</b>	



## D3514-1 BEND DETAIL



## UNDER REVIEW

07.05.24cb

## D3514-1 BOX TOP (BOTTOM MOUNTED)

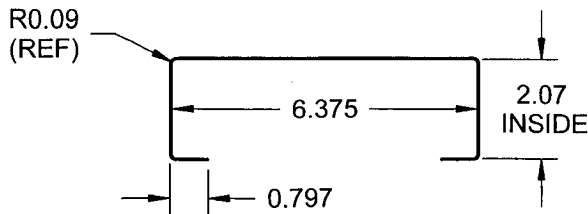
- NOTES:
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
  - 6) PART IS SYMMETRIC ABOUT C
  - 7) C/SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)
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WORK ORDER  
32536  
P.O.

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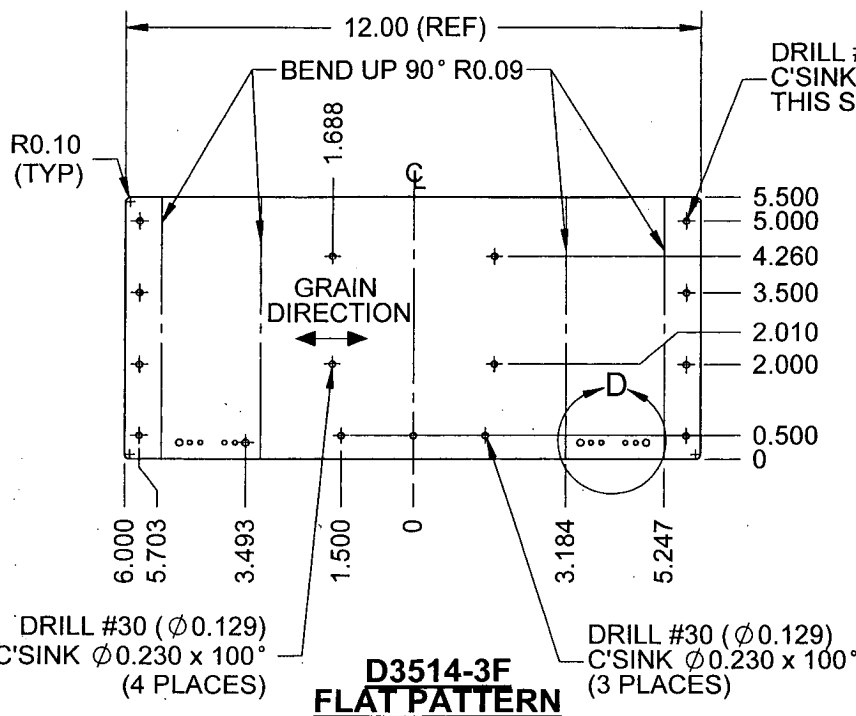
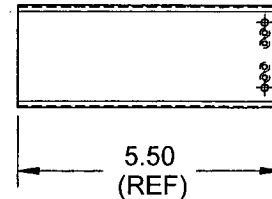
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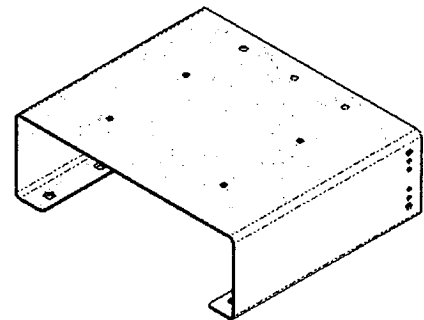
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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 6 OF 9
DATE 07.01.10	TITLE GPS RECEIVER HOUSING		SCALE 1:4



**D3514-3  
BEND DETAIL**



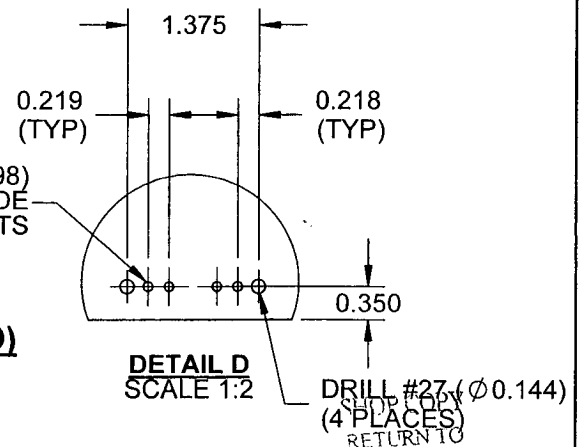
**D3514-3F  
FLAT PATTERN**



**UNDER REVIEW**  
07.05.14 CB

DRILL #40 (Ø0.098)  
C'SINK Ø0.182 x 100° THIS SIDE  
(8 PLACES) FOR RIVETS

**D3514-3 BOX TOP (TOP MOUNTED)**



**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

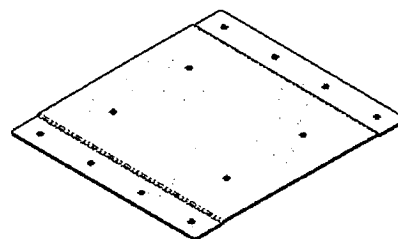
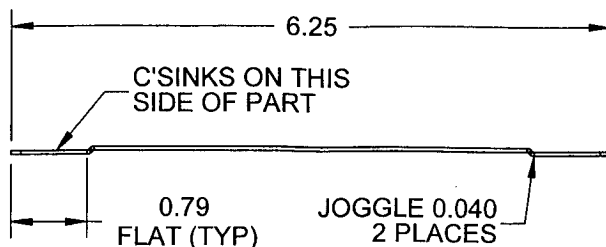
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NO. 32536

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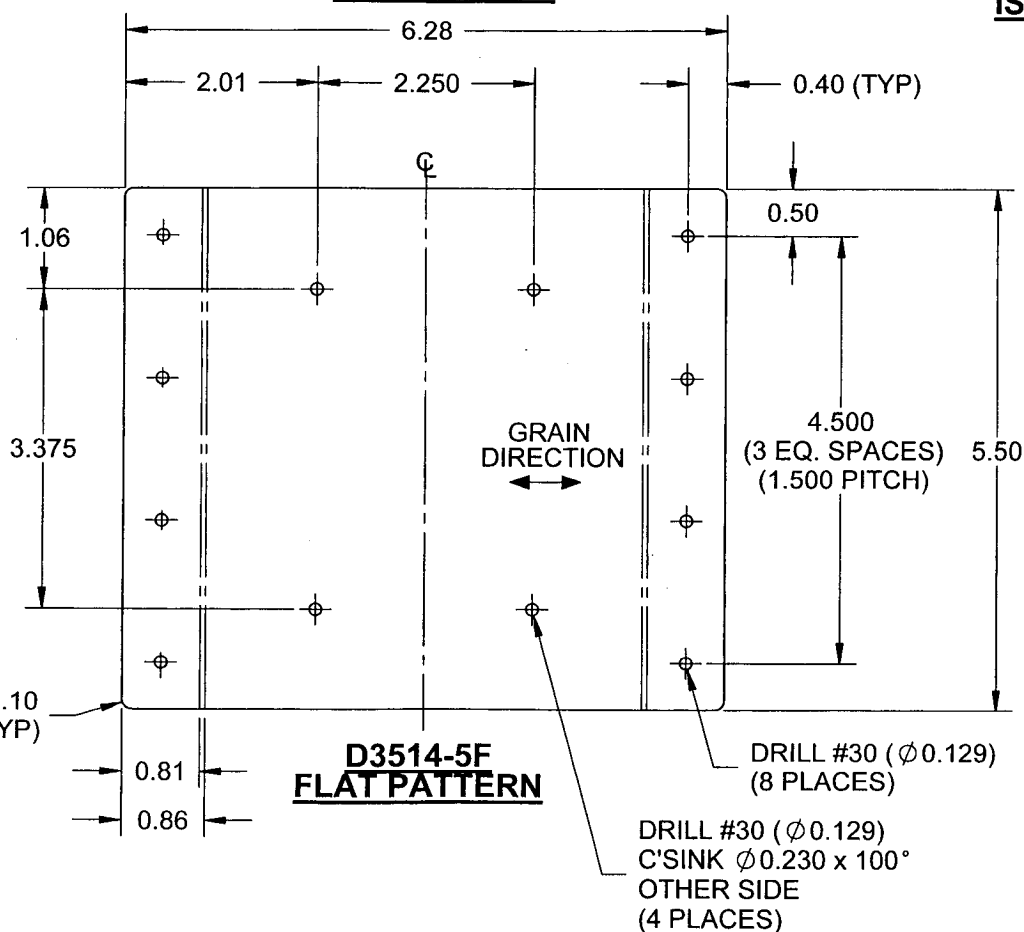
**PRELIMINARY ISSUE**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED AJ	DRAWING NO. D3514	REV. A SHEET 7 OF 9
DATE 07.01.10	TITLE GPS RECEIVER HOUSING SCALE 1:2		



**ISOMETRIC VIEW**  
SCALE 1:4

**D3514-5  
BEND DETAIL**



**D3514-5F  
FLAT PATTERN**

**D3514-5 BOX BOTTOM (BOTTOM MOUNTED)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$
- 7) C'SINK BELOW JOGGLE

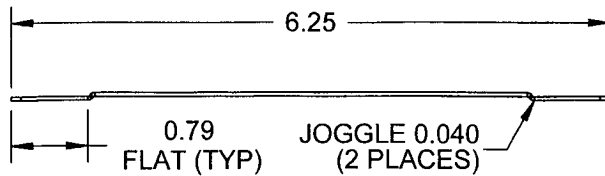
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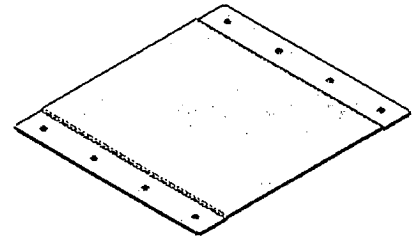
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**PRELIMINARY ISSUE**

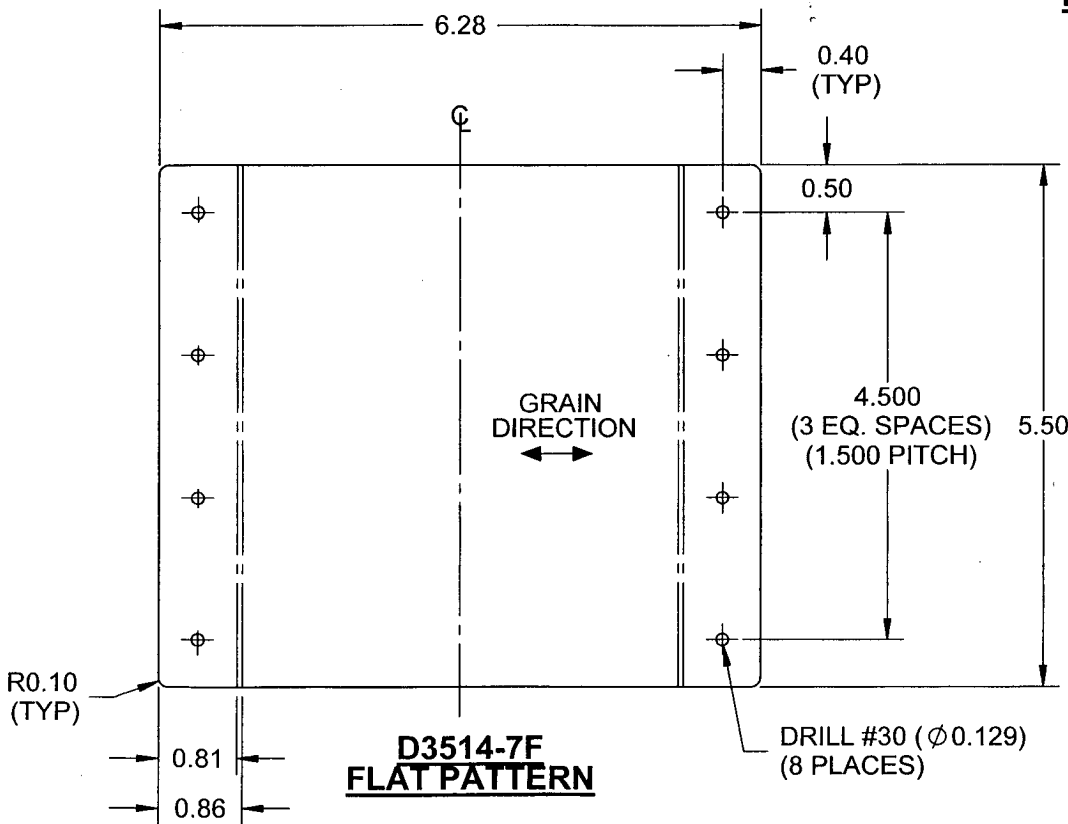
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. D3514	REV. A SHEET 8 OF 9
DATE 07.01.10		TITLE GPS RECEIVER HOUSING	SCALE 1:2



**D3514-7  
BEND DETAIL**



**ISOMETRIC VIEW  
SCALE 1:4**



**UNDER REVIEW**  
07.05.2010

**D3514-7 BOX BOTTOM (TOP MOUNTED)**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

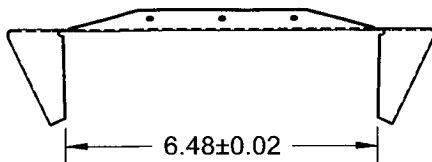
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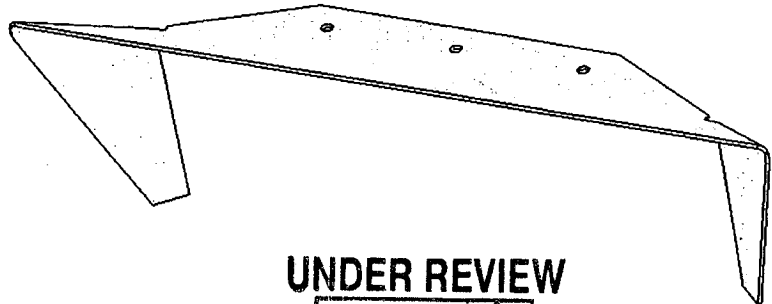
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**PRELIMINARY ISSUE**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 9 OF 9
DATE 07.01.10		TITLE GPS RECEIVER HOUSING	SCALE 1:2



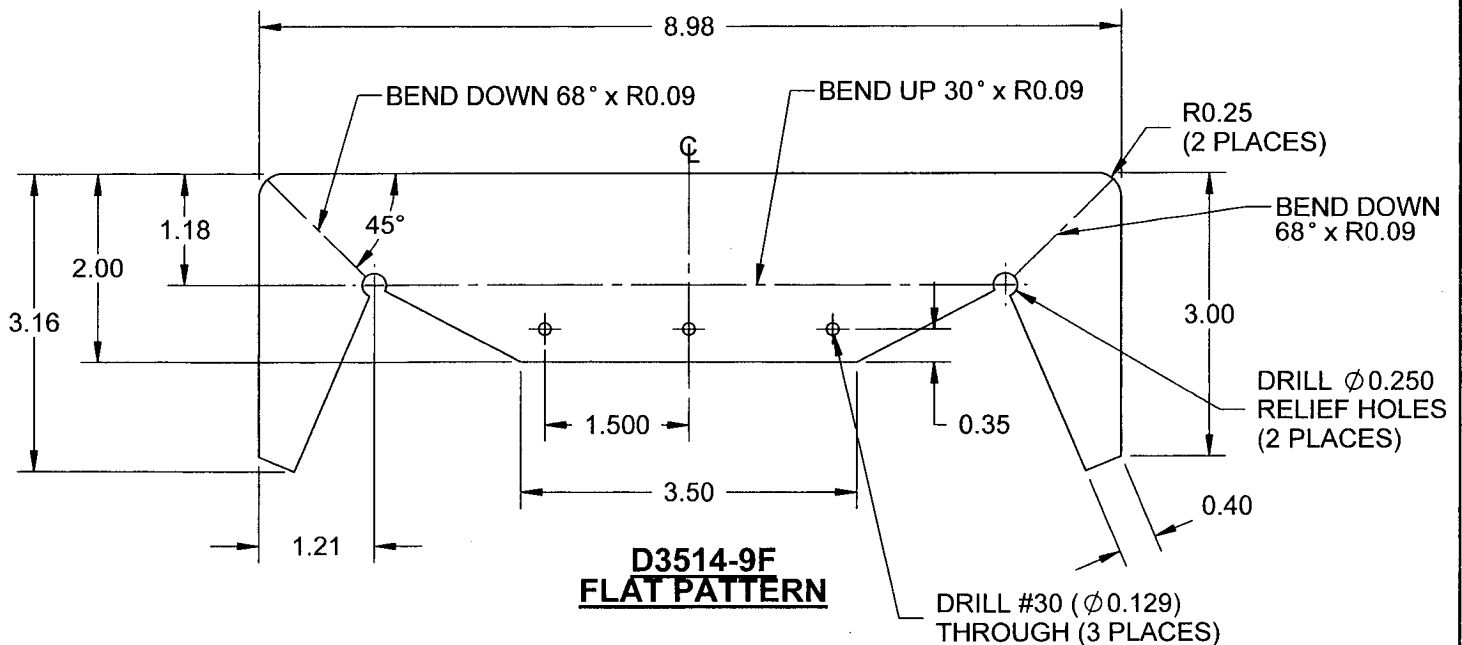
**FRONT VIEW**  
SCALE 1:4



**UNDER REVIEW**

07.05.24 CB

**D3514-9  
BEND DETAIL**



**D3514-9F  
FLAT PATTERN**

**D3514-9 HOOD**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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NO. 32536

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DART AEROSPACE LTD		Work Order: 32536
Description: GPS Receiver Housing		Part Number: D3514-3
Inspection Dwg: D3514	Rev: Rev	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.129$	$+0.005-0.001$	0.131	✓		vern	
B $\phi 0.144$	$+0.005-0.001$	0.146	✓		vern	
C $\phi 0.098$	$+0.004-0.001$	0.101	✓		vern	
D 5.500	$\pm 0.010$	5.506	✓		vern	
E 12.00	$\pm 0.030$	12.00	✓		Measuring tape	
F 5.000	$\pm 0.010$	5.000	✓		vern	
G 4.260	$\pm 0.010$	4.263	✓		vern	
H 2.010	$\pm 0.010$	2.010	✓		vern	
I 2.000	$\pm 0.010$	2.001	✓		vern	
J 0.500	$\pm 0.010$	0.501	✓		vern	
K 6.000	$\pm 0.010$	6.005	✓		vern	
L 5.703	$\pm 0.010$	5.701	✓		vern	
M 1.500	$\pm 0.010$	1.500	✓		vern	
N 3.493	$\pm 0.010$	3.496	✓		vern	
O R0.10	$\pm 0.030$	R0.10	✓		vern	
P 0.218	$\pm 0.010$	0.218	✓		vern	
Q 0.219	$\pm 0.010$	0.218	✓		vern	
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>ML ML</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 010529	Date: 010529	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved